

Work Order ID 60840

Monday, July 26, 2010 9:49:57 AM

Page 1

Item ID: D3929-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset Assembly

Start Date: 7/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: HDate: 10-7-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3929

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-7-27

⑥

B10-7-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

0.00

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M114619

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

⑥ PD 10.09.04

x6

BE 10/08/10
JL

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Required Date: 7/30/2010 Req'd Qty: 6.00

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup

Start

Stop

Run

Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 10/08/10

46
-012

170

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

Packaging

SPD
10-08-11

6

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/11

MF 10-8-11

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 9:50:02 AM

Page 1

Work Order ID: 60840

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 7/26/2010

Required Date: 7/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	99.7009	0.45	2.842105			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT			99.7009						
				114488			1.5259						
				114799			98.175						
D3907-1  Bushing		Manufactured	No			130	Each	77.0000	2	12			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			77						
				60273			36						
				60720			41						



10-7-27

6

114799



10.09.09

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

8

7

6

5

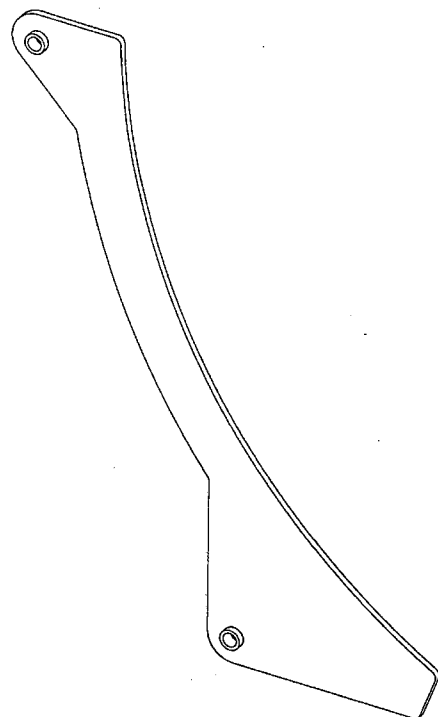
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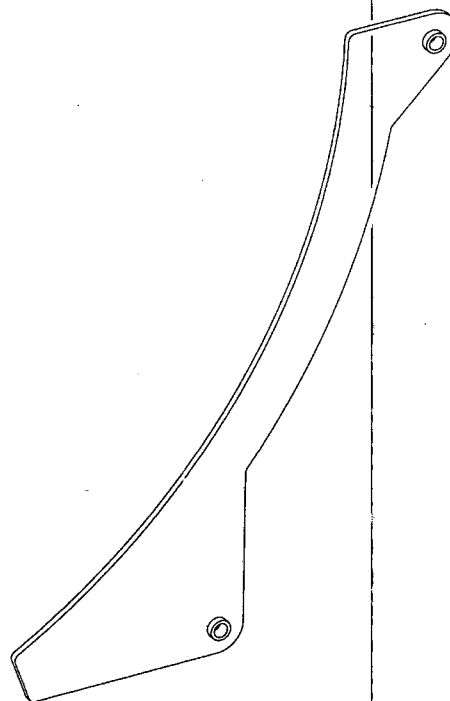
2

1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

60840

RELEASED
8/29/12

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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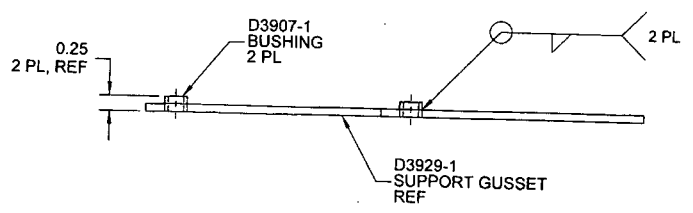
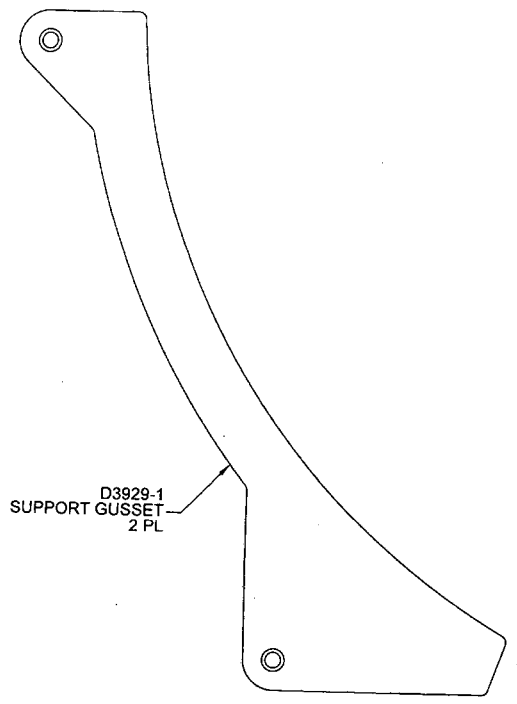
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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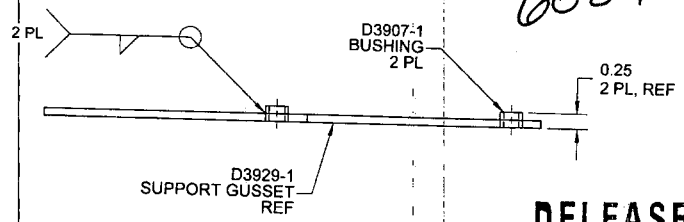
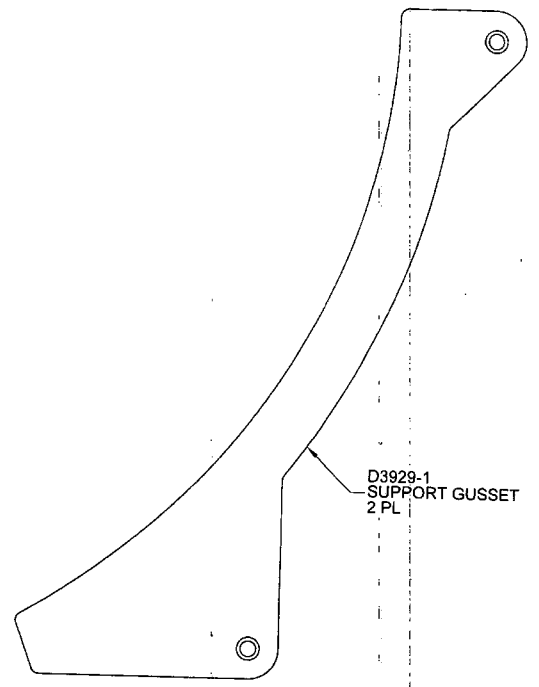
8 7 6 5 4 3 2 1

D
C
B
A



D3929-041 GUSSET ASSEMBLY

8 7 6 5 4 3 2 1



D3929-042 GUSSET ASSEMBLY

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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DE APPR.		GUSSET ASSEMBLY	NTS
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RELEASED
09/04/22 MD

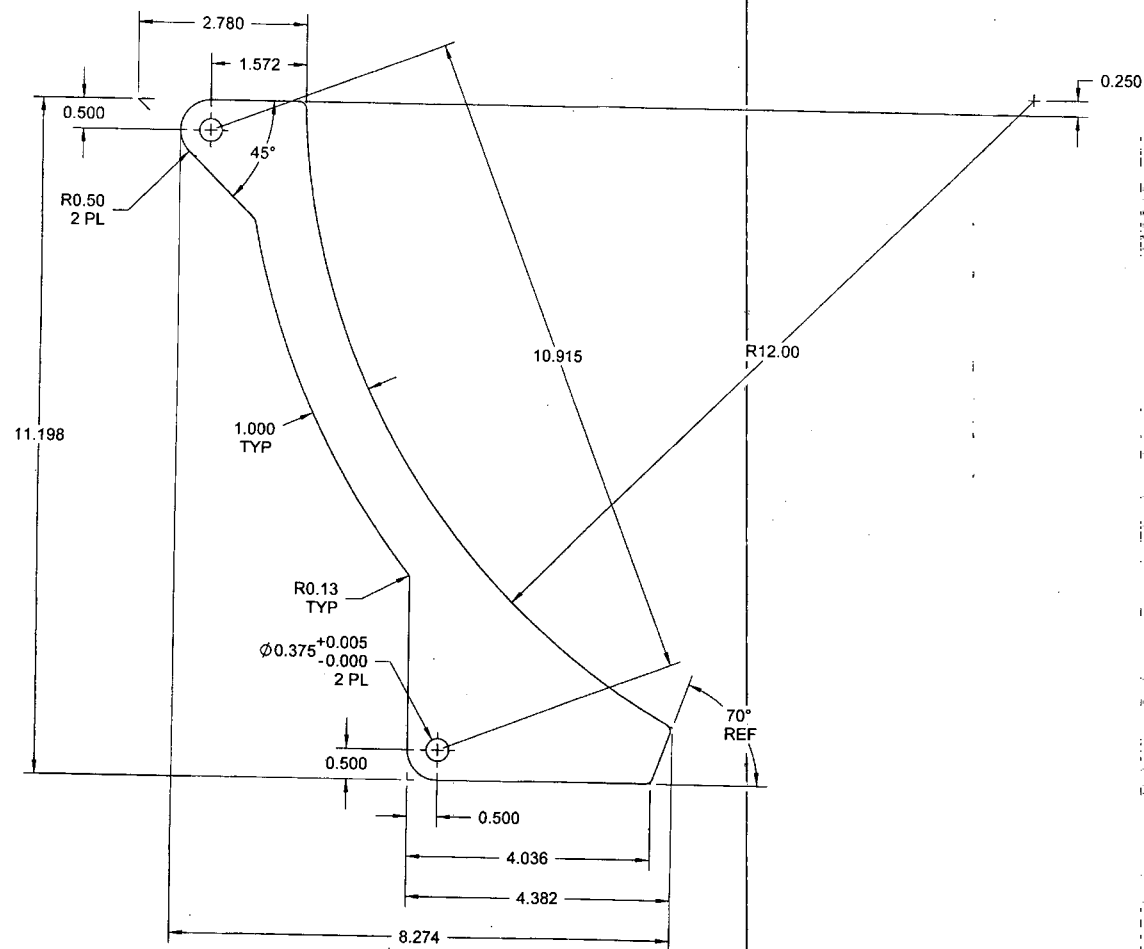
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


NOTE: Date & initial all entries



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3929	SHEET 3 OF 3
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9/04/22 M/D

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